

LSAP

Date: Monday, 26/05/2008 9:58:57 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 39479	
Estimate Number : 13315	
P.O. Number :	Part Number : D37933
This Issue : 26/05/2008 S.O. No. :	Drawing Number : D3793 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 39420	Material :
Written By :	Due Date : 02/06/2008 Qty: 30 Um: Each
Checked & Approved By :	
Comment : Est Rev:A 08-05-13 new issue DD verified by:EC Est Rev:B 08-05-23 revA as per dwg DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 1.3469 sf(s)/Unit Total : 26.9388 sf(s)
304/316 .040 Sheet
(M304S20GA)
Batch: 108118 B 8-5-26

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D3793
Dwg Rev: A
Prog Rev: A

B 8-5-26



2-Deburr if necessary B 8-5-26

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B 8-5-26

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

counted
S 08/05/27 (x30)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
1-Deburr if necessary

2-Form on Brake as per Dwg D3793 using Jigs

SP 08/05/27

30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 26/05/2008 9:58:57 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 39479

Part Number: D37933

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/05/27 x30 gantes

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3

START TIME:

8:00

OVEN TEMPERATURE:

320°

FINISH TIME:

8:30

FL

08/05/28

(30)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L

08/05/28

(30X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-17

RD

08/05/28

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/29

Job Completion



MF 08-05-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

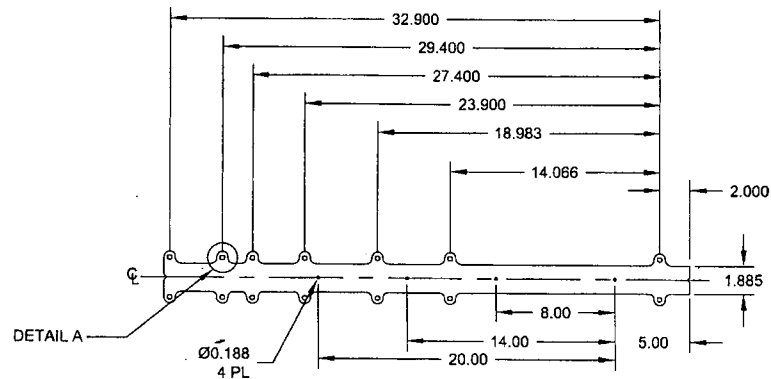
QA: N/C Closed: _____ Date: _____

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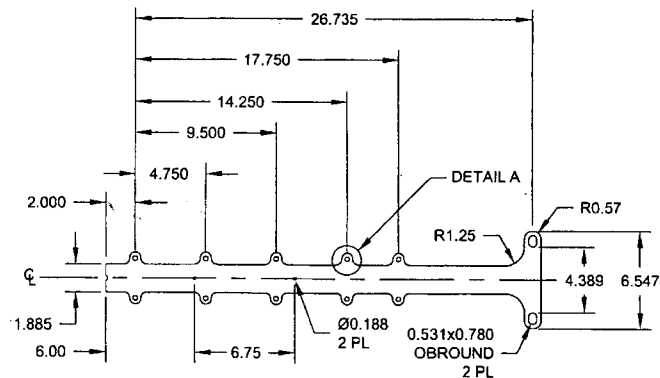
8 7 6 5 4 3 2 1

D



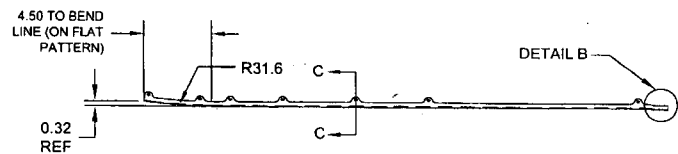
D3793-1F FLAT PATTERN

C



D3793-3F FLAT PATTERN

B



D3793-1 BEND DETAIL
(MAKE FROM D3793-1F)



D3793-3 BEND DETAIL
(MAKE FROM D3793-3F)

RELEASED
08.05.14

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

A		NEW ISSUE		PH	08.05.14
REV.		DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE USA, INC			
DRAWN		PORT HADLOCK, WA			
CHECKED		DRAWING NO.		REV. A	
MFG. APPR.		D3793		SHEET 1 OF 2	
APPROVED		TITLE		SCALE	
DE APPR.		WEARSHOE		NTS	
DATE		COPYRIGHT © 2008 BY DART AEROSPACE USA, INC			
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8 7 6 5 4 3 2 1

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

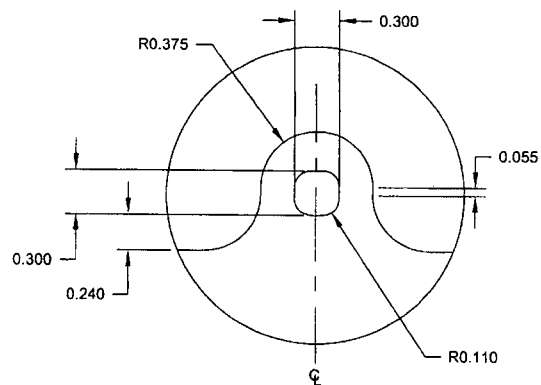
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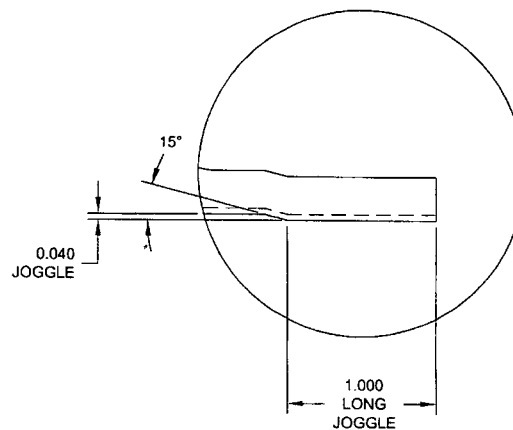
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D



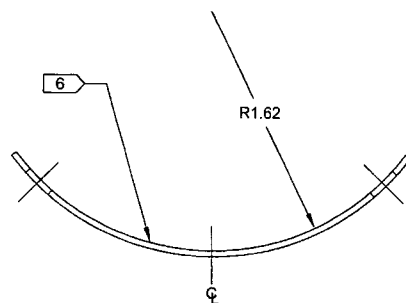
DETAIL A
SCALE 10X

C



DETAIL B
SCALE 10X

B



SECTION C-C
SCALE 10X

A

8 7 6 5 4 3 2 1

RELEASED
08-05-23/178

2/10/30/178

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3793	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE	NTS
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